Work Order ID   55468

January 19, 2010 9:51:08 AM

Item ID:	D3558-3	**Accept**
Revision ID:		
Item Name:	Gasket	

Start Date:	1/19/10	**Start Qty:**	12.00	
Required Date:	1/25/10	**Req'd Qty:**	12.00	

Reference:

Setup **Start**

Stop

Run **Start**

Stop

Approvals:	**Process Plan:**	*PL*	**Date:** 10-1-19	**Tooling:** ... **Date:**
	QC:		**Date:**	**SPC (Y/N):** ... **Date:**

Cust Item ID:
Customer:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D3558	Rev B								
100		0.00							
Waterjet	FLOW WATER JET							ß 10-1-20	②
FLOW CNC Waterjet	Memo	0.00							
	1-Cut as per Dwg D3558 ...Dwg Rev: ß : Prog Rev: ß .2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC								ß 10-1-20	
Quality Control	Memo	0.00							
120	QC8- Inspect parts - second check	0.00 ϽS 10-16-1-20							+12
QC									
Quality Control	Memo	0.00							

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WORK ORDER CHANGES

W/O:								
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign &** **Date**	**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector

NOTE: Date & initial all entries

Item ID:	D3558-3		Accept		Setup	Start	
Revision ID:						Stop	
Item Name:	Gasket						

| Start Date: | 1/19/10 | Start Qty: | 12.00 | | Cust Item ID: | |
| Required Date: | 1/25/10 | Req'd Qty: | 12.00 | | Customer: | |

Reference:

					Run	Start	
Approvals:	Process Plan:	Date:	Tooling:	Date:		Stop	
	QC:	Date:	SPC (Y/N):	Date:			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: *FP*	0.00							
Packaging	Memo	0.00				*LC*	*10/61/20*		*(12)*
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00					*10/61/20*		
Quality Control									*MF 10-1-20*

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W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

Picklist Print

January 19, 2010 9:51:12 AM

Work Order ID: 55468

Parent Item: D3558-3

Parent Item Name: Gasket

Comments: IPP Rev:A   New Issue 06-12-15 JLM
Ets Rev:B   Rev B dwg 07-12-06 DD

Start Date: 1/19/10   **Required Date:** 1/25/10

Start Qty: 12.00   **Required Qty:** 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	754.1060	9.5015			
NEOPRENE SHEET 0.063												

ß 10-1-20

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT	754.106	
112508	61.6034	_____
112662	290.2821	_____
112866	154.11	_____
113058	248.1105	113058

(B)

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W/O:								
**WORK ORDER CHANGES**							
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		**WORK ORDER NON-CONFORMANCE (NCR)**						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action**　Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article   [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	✗			
0.30	+/-0.030	.302	✗			
0.30	+/-0.030	.304	✗			
0.38	+/-0.030	.375	✗			
2.73	+/-0.030	2.735	✗			
2.06	+/-0.030	2.058	✗			
5.63	+/-0.030	5.633	✗			
33.75	+/-0.030	33.75	✗			
36.13	+/-0.030	36.13	✗			

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	10-1-20	Date:	10/01/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.01.17	New Issue	KJ/JLM	
B	08.04.17	Dimensions updated per Dwg Rev B	KJ/DD	

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WORK ORDER CHANGES

W/O:				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No   DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

D3558-1 GASKET
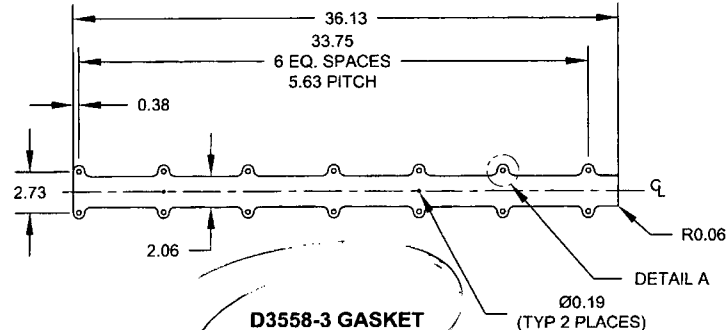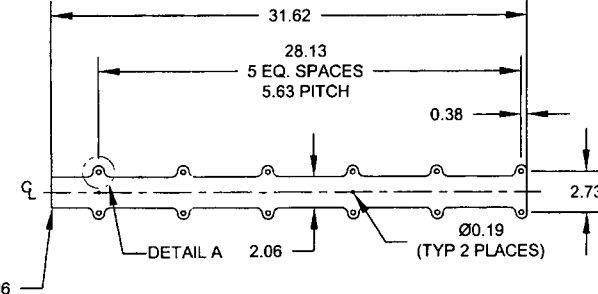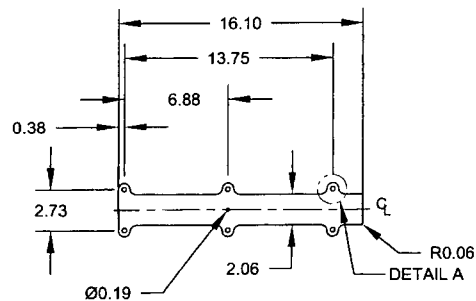
11.60
5.80 (TYP)
0.38 (TYP)
DETAIL A
2.73
Ø0.19
2.06

D3558-3 GASKET

36.13
33.75
6 EQ. SPACES
5.63 PITCH
0.38
2.73
2.06
R0.06
DETAIL A
Ø0.19 (TYP 2 PLACES)

D3558-5 GASKET

31.62
28.13
5 EQ. SPACES
5.63 PITCH
0.38
2.73
DETAIL A   2.06
Ø0.19 (TYP 2 PLACES)
R0.06

D3558-7 GASKET

16.10
13.75
6.88
0.38
2.73
Ø0.19
2.06
R0.06
DETAIL A

D3558-9 GASKET

17.40
11.60
0.38 (TYP)
5.80
2.73
DETAIL A
Ø0.19
2.06
2.90

D3558-11 GASKET

26.50
22.50
4 EQ. SPACES
5.50 PITCH
DETAIL A
0.38
R0.06
2.73
2.06
Ø0.19

D3558-13 GASKET

7.88
5.63
0.38
DETAIL A
2.73
2.06
R0.06
Ø0.19

DETAIL A
(SCALE 1:2)

0.30
R0.37 (TYP)
R0.11 (TYP)
0.19 (REF)
0.75
R0.38 (TYP)
0.30
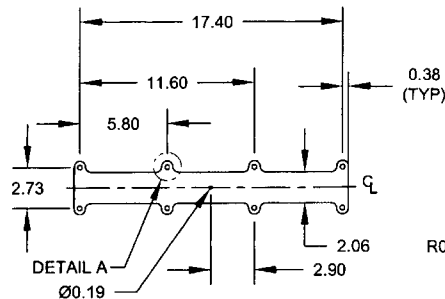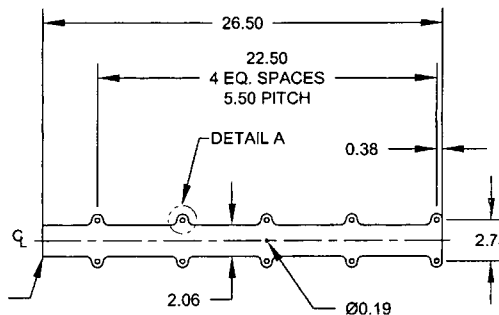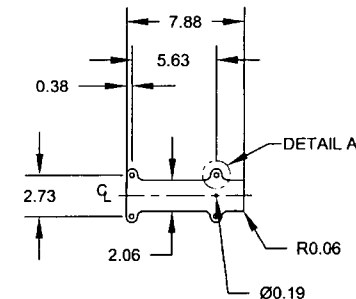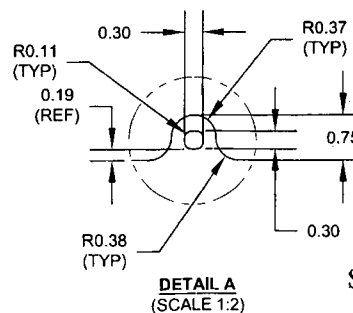
NOTES:
1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER
                  (REF. DART SPEC. M-NEW60-S.063)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: NONE
7) WEIGHT: D3558-1 - 0.09 lbs, D3558-3 - 0.26 lbs, D3558-5 - 0.23 lbs,
                  D3558-7 - 0.12 lbs, D3558-9 - 0.13 lbs, D3558-11 - 0.19 lbs,
                  D3558-13 - 0.06 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 55468

RELEASED
07.11.16

B	ADD -9/-11/-13 UPDATE DRAWING FORMAT		PH	07.04.20
A	NEW ISSUE		PH	06.09.15
REV.	DESCRIPTION		BY	DATE

DESIGN		**DART AEROSPACE USA, INC**	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3558	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		GASKET	1:8
DATE 07.04.20		COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action — Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries